

Blue.

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 1.

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/18/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-04 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2650	F(DEO)
-------	--------

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-341 CHG004

N/A MLJ 1406-02

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 2

Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube(Fits LH or RH)
 Start Date: 3/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/18/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/RAluminum Rod <u>m125127/m128385</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to lenght as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297"								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650								
	11-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)								
	12-Deburr.								

DGL 14-4-16

BE14-0416

DC 14/04/21

DGL 14-4-17

March-04-14 11:57:02 AM

Page 3

[illegible]

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 4

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/18/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC7-Inspect Chemical Conversion Coat	0.00							
125									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Bond D2654-5 web in place as per QSI 015 Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: 14-4-17 Time: 10:10 Finish Date: _____ Time: _____ A/RSikaflex-291 128026 Sikaflex expiry date: 14-10-09								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
03
9-89

DD

14-4-17

DGC / JLL

14-4-17

DAS
03
9-89

DD

14-4-21

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 5

Item ID: D206-642-341 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube(Fits LH or RH)
 Start Date: 3/04/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/18/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
	2- Install nut plate as per dwg								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 6

Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube(Fits LH or RH)
 Start Date: 3/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/18/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205		0.00							
205						1	0	0	14517
SprayPaint	Memo	0.00							
Spray Painting	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	1-Prime inside and outside crosstube as per QSI 005 4.2								
	B _____								
	2-Paint outside crosstube as per QSI 005 4.2 DELFEET BLUE								
	B _____								
	PRIME: 128927								
	Start Time: _____								
	Finish Time: _____								
	PAINT: 127671								
	Start Time: _____								
	Finish Time: _____								
	CLEAR DELFLEET B 125385								
215	QC14- Inspect Spray Paint	0.00							
215									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

1x d 81 14/05/20

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 7

Item ID: D206-642-341 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 3/18/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing	0.00				1x	4	41	11/05/20
Hand Finish	Memo								
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 11128979 Sikaflex expiry date: 15101								
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive								
	3-Install MS27039-4-06 Screw								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 11128979 Sikaflex expiry date: 15101								
	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: 11128909								

1x 4 11128979 15101/20

Work Order ID 114080

March-04-14 11:57:02 AM

114080

Page 8

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/18/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC3- Inspect Part Finish

0.00 DAS

230

27

QC

Memo

0.00

S-89

Quality Control

M/S/21

240 QC5- Inspect part completeness to step on W/O

0.00 DAS

240

27

QC

Memo

0.00

S-89

Quality Control

M/S/21

250 Packaging

0.00

250

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location: _____

PPP Rev: _____

114554

APR 28 2014

DAS
06
9-22

Work Order ID 114080

114080

Page 9

March-04-14 11:57:02 AM

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/18/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260 QC21- Final Inspection - Work Order Release

0.00

260

QC Memo

0.00

Quality Control

MLJ 140602
MLJ 140530

March-04-14 11:57:05 AM

1 14080

D206-642-341

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf:DD IPP Rev:L 12.11.22 now swage per ecn12-679 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No				Each	228.0000		2			
CCR264SS3-3									**			DC 14/04/21	
Cherry Rivet	-03 *												
				<u>Location</u>	B127363			<u>Loc Qty</u>		<u>Loc Code</u>		(2)	
				ST327				228					
				m126282				106					
				m126333				122					
CR3212-4-03		Purchased	No				Each	1,161.000		2			
CR3212-4-03									**			DC 14/04/21	
Cherry Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST327				1061					
				114889				1					
				119017				700					
				m123265				360					
				st552				100				(2)	
				m114859				100					
D2620		Manufactured	No				Each	5.0000		1			
D2620									**				
Skidtube, 206 Skidtube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				5				(1)	DEL 14-4-16
				110799				5					

Picklist Print

March-04-14 11:57:05 AM

Page 2

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

D2647

Manufactured No

Each 16.0000 1

D2647

Cap

*BE 14-04-16
8114961 x1*

Location

Loc Qty

Loc Code

LG001

16

107588

1

110701

15

D2654-5

Manufactured No

Each 1.0000 1

D2654-5

Web

Location

Loc Qty

Loc Code

LG

1

110451

1

*① DGC 14-4-07
JLC*

D2680-041

Manufactured No

Each 18.0000 1

D2680-041

Nut Plate

DC 14/04/21

Location

Loc Qty

Loc Code

ST014

18

108819

18

①

MS27039-1-08

Purchased No

Each 504.0000 2

MS27039-1-08

Screw

HL 14/03/20

Location

Loc Qty

Loc Code

GA

19

m125654

19

st507

485

m127255

485

M128636 x2

March-04-14 11:57:05 AM

Shop Packet Print

Page 2

Picklist Print

March-04-14 11:57:05 AM

Page 3

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

Each

91.0000

54

MS27039C1-08

SCREW

HL 1/05/20

Location

Loc Qty

Loc Code

ST309

91

M128650

X54

123352

12

m127255

79

NAS1149D0463J

Purchased

No

Each

4,675.000

1

NAS1149D0463J

WASHER

HL 1/03/20

Location

Loc Qty

Loc Code

ST294

450

M128591

X1

M127693

450

ST510a

4225

M127813

1225

M127904

3000

D4720-1

Manufactured

No

150

Each

113.0000

19

19

D4720-1

Spacer

DL 14/04/21

Location

B114582

Loc Qty

Loc Code

LG001

113

19

103902

113

ALS4-1032-130

AELS4-1032-130

Purchased

No

220

Each

1,176.000

54

54

ALS4-1032-130

Rivnut

HL 1/05/20

Location

Loc Qty

Loc Code

ST279

1119

M128649

X54

M128179

158

M128211

961

st510

57

M126109

57

March-04-14 11:57:05 AM

Shop Packet Print

Page 3

Picklist Print

March-04-14 11:57:05 AM

Page 4

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

61.0000

1

1

D2646

Aft Cap

sl 11/05/20

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

57

103306

18

107857

1

110816

38

xl

D2651-1

Manufactured No

220

Each

502.0000

14

14

D2651-1

Plug

sl 11/05/20

Location

Loc Qty

Loc Code

FP001

502

103305

30

104843

1

106456

135

111875

134

112725

202

B114496

xl

D2651-3

Manufactured No

220

Each

328.0000

14

14

D2651-3

O-Ring

sl 11/05/20

Location

Loc Qty

Loc Code

FP001

328

104725

68

108583

160

110659

100

xl

March-04-14 11:57:05 AM

Shop Packet Print

Page 4

Picklist Print

March-04-14 11:57:05 AM

Page 5

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220

Each

14.0000

1

1

D3535-11

Stainless Steel Wearplate Fwd

**

xl 11/05/20

Location

Loc Qty

Loc Code

FP002

14

B 115180

xl

109608

7

112577

7

D3535-23

Manufactured No

220

Each

38.0000

1

1

D3535-23

Stainless Steel Wearplate Center Fwd

**

xl 11/05/20

Location

Loc Qty

Loc Code

FG

2

93181

2

FP001

1

107951

1

FP002

35

110063

10

110677

6

112243

6

113033

13

xl

D3535-35

Manufactured No

220

Each

31.0000

1

1

D3535-35

Stainless Steel Wearplate Aft

**

xl 11/03/20

Location

Loc Qty

Loc Code

FG

2

94685

2

FP002

29

110763

3

112440

10

113151

16

xl

B 113732

March-04-14 11:57:05 AM

Shop Packet Print

Page 5

Picklist Print

March-04-14 11:57:05 AM

Page 6

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

220

Each

12.0000

1

1

D3536-11

Gasket Fwd

**

ll 14/05/20

Location

Loc Qty

Loc Code

FP001

8

B115112

110787

8

✓

ST500

4

46715

4

D3536-23

Manufactured No

220

Each

30.0000

1

1

D3536-23

Gasket Center

**

ll 14/05/20

Location

Loc Qty

Loc Code

FG

2

B114897

85295

2

✓

FP001

28

112179

15

113010

13

D3536-35

Manufactured No

220

Each

36.0000

1

1

D3536-35

Gasket Aft

**

ll 14/05/20

Location

Loc Qty

Loc Code

FG

6

B115037

89650

2

✓

93911

4

FP001

30

112374

8

113111

16

113306

6

March-04-14 11:57:05 AM

Shop Packet Print

Page 6

Picklist Print

March-04-14 11:57:05 AM

Page 7

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

220

Each

29.0000

6

6

D3537-1

Wearpad

Handwritten: 1405120

Location

Loc Qty

Loc Code

FG

18

79833

8

Handwritten: B113358

Handwritten: x6

88562

10

FP001

11

111594

11

D3537-3

Manufactured No

220

Each

33.0000

1

1

D3537-3

Wearpad

Handwritten: 1405120

Location

Loc Qty

Loc Code

FG

8

86237

8

Handwritten: B115123

Handwritten: x1

FP001

12

111825

12

FP002

13

103014

13

MS27039-4-06

Purchased No

220

Each

81.0000

1

1

MS27039-4-06

Screw

Handwritten: 1405120

Location

Loc Qty

Loc Code

ST306

81

m126534

81

Handwritten: v1

March-04-14 11:57:05 AM

Shop Packet Print

Page 7

Picklist Print

March-04-14 11:57:05 AM

Page 8

Work Order ID: 114080

114080

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube(Fits LH or RH)

Start Date: 3/04/14

Required Date: 3/18/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

220

Each

7,824.000

54

54

NAS1149C0332R

WASHER

HL 14/05/20

Location

Loc Qty

Loc Code

GA

1125

M128591

x54

125654

1125

st510

6699

m126319

89

m127306

2500

m127410

3000

m127831

1110

NAS1149D0332J

Purchased

No

220

Each

934.0000

2

2

NAS1149D0332J

Washer

HL 14/05/20

Location

Loc Qty

Loc Code

GA

179

M128606

x2

m127916

179

ST293

412

m127389

27

m127431

385

ST294

5

m125807

5

ST510a

338

m127916

338

March-04-14 11:57:05 AM

Shop Packet Print

Page 8

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

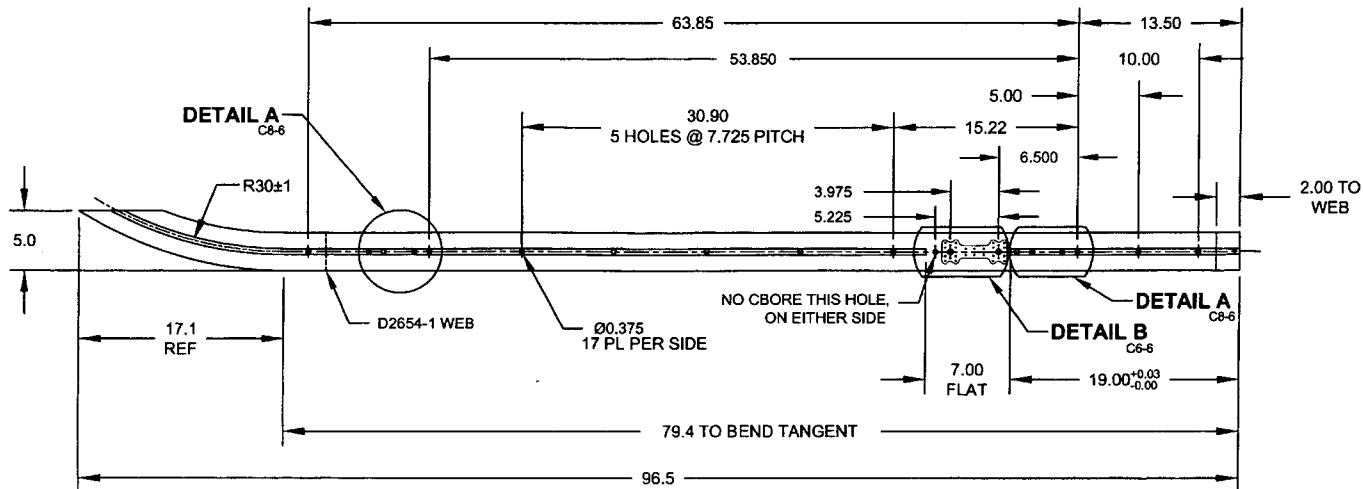
114080MLJ
1Y-03-04

DEO ATTACHED
RELEASED
08-07-23/17

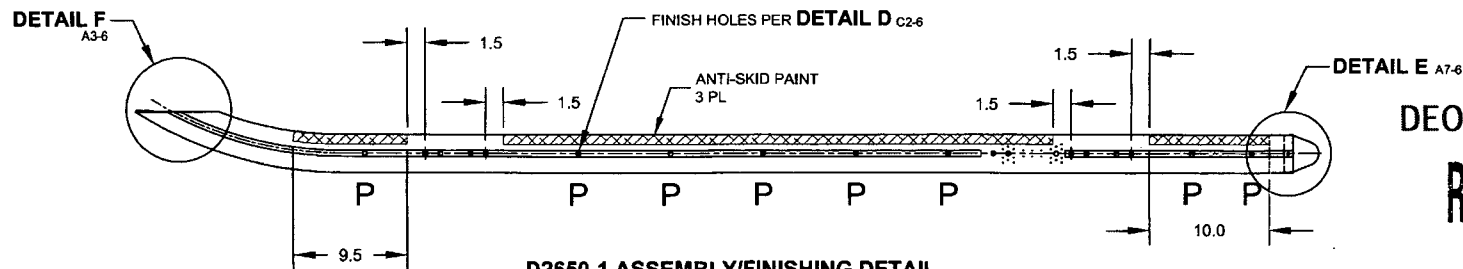
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



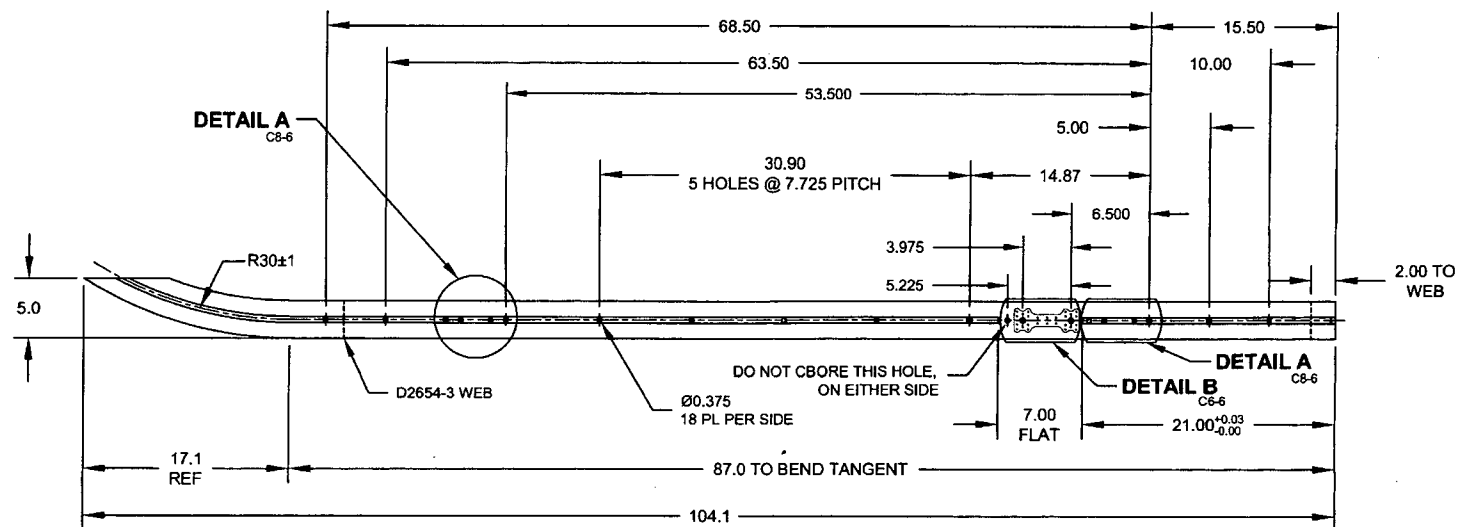
D2650-1 BENDING/DRILLING DETAIL



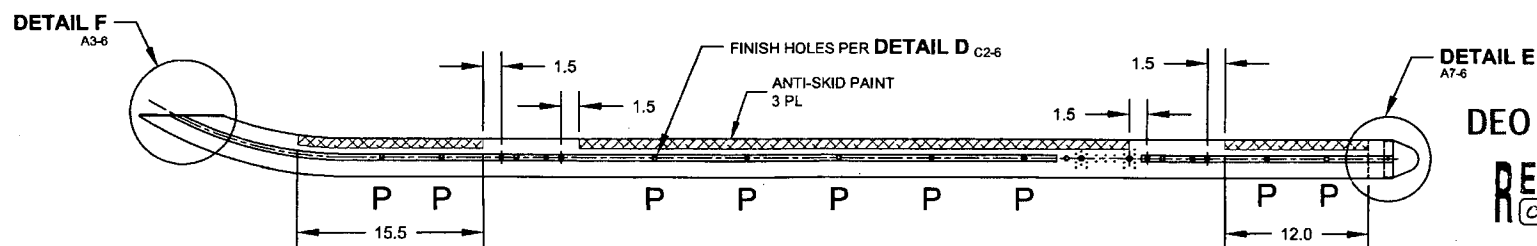
D2650-1 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED
RELEASED
880922/117

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



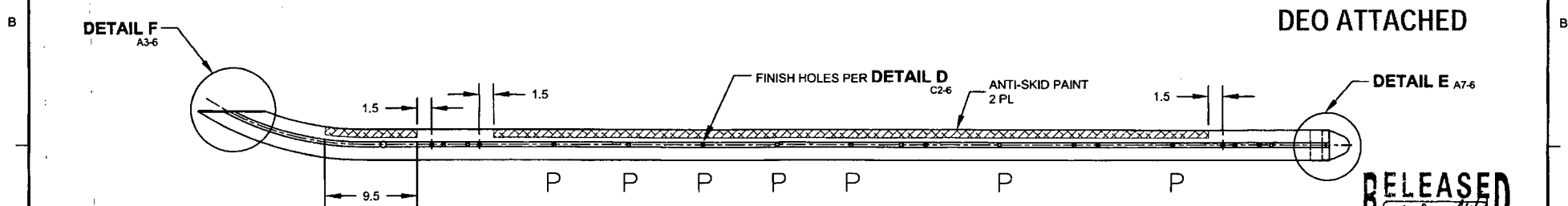
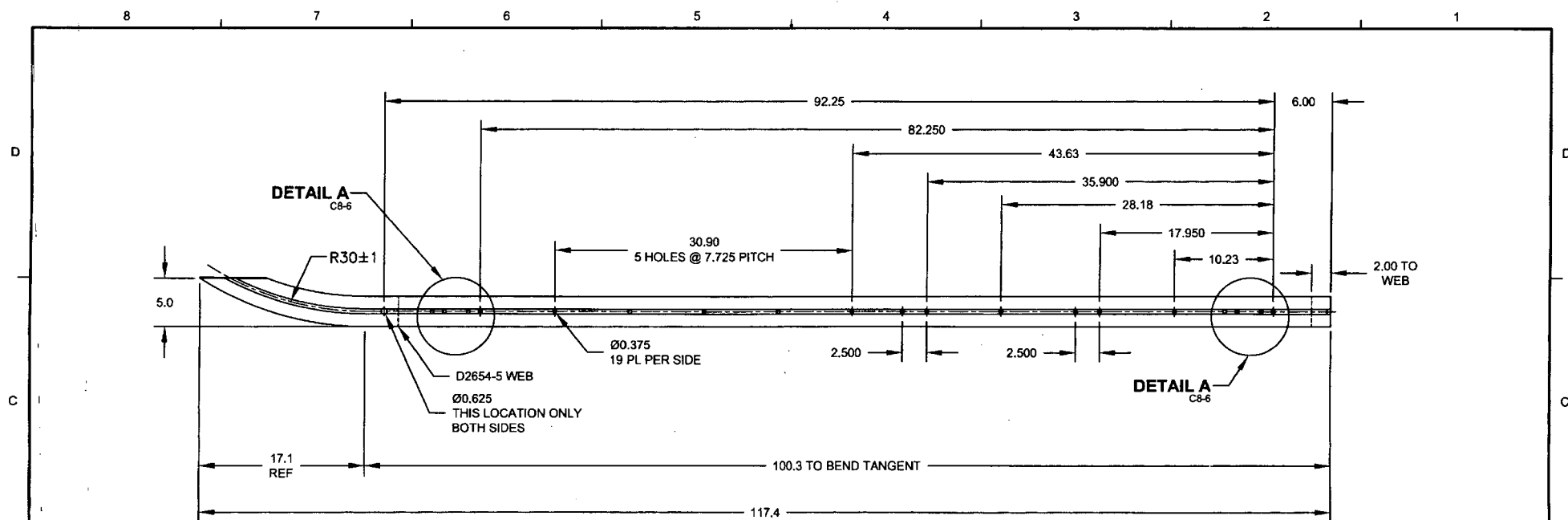
D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

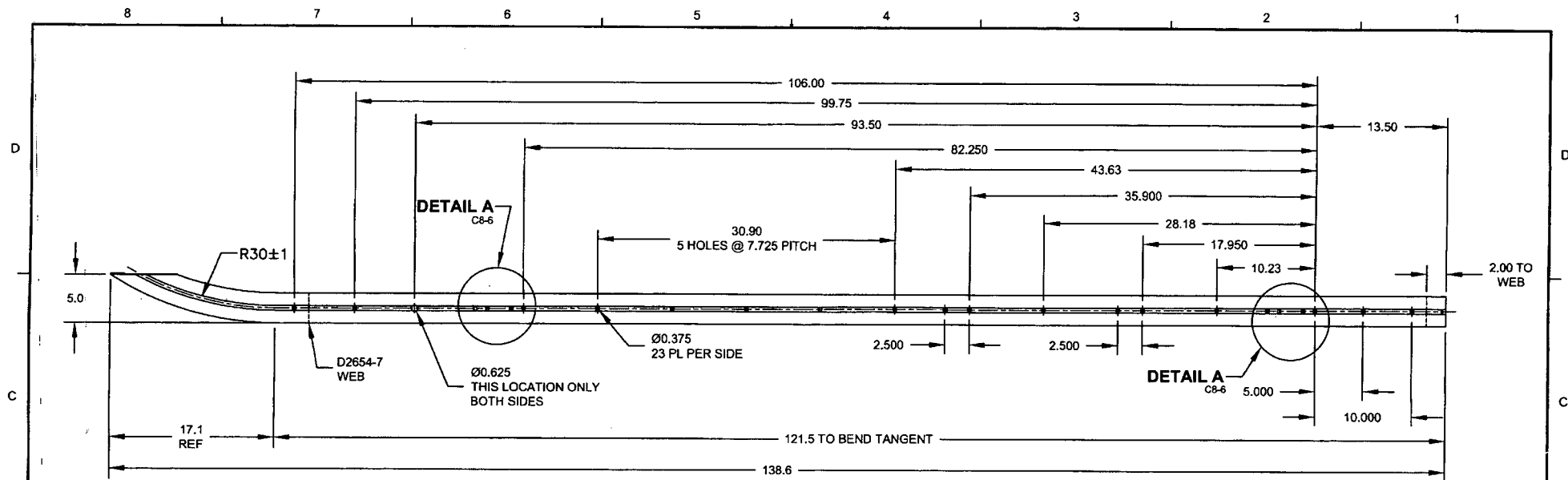
DEO ATTACHED
RELEASED
08 07 22 118

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



RELEASED
08.09.22/11/17

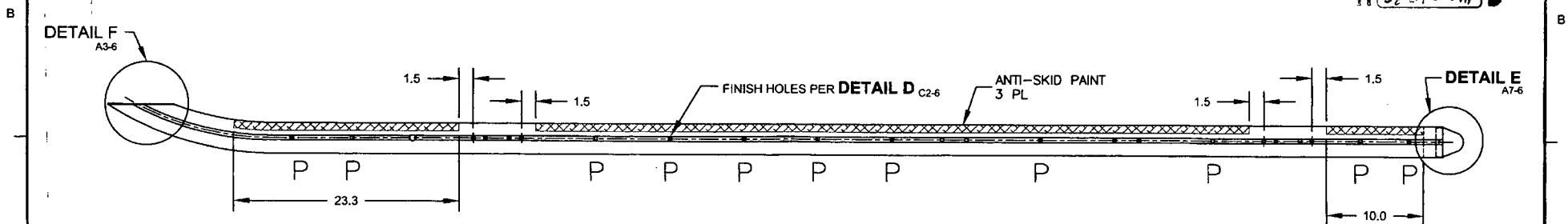
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2650-7 BENDING/DRILL DETAIL

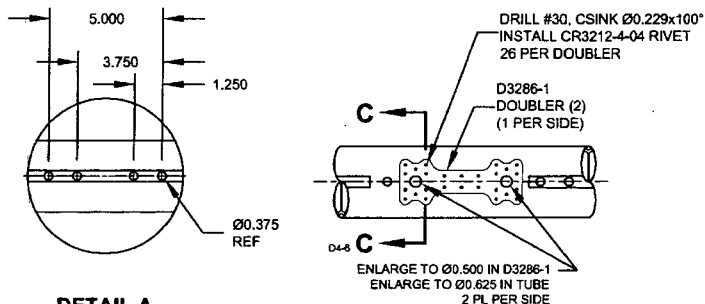
DEO ATTACHED

RELEASED

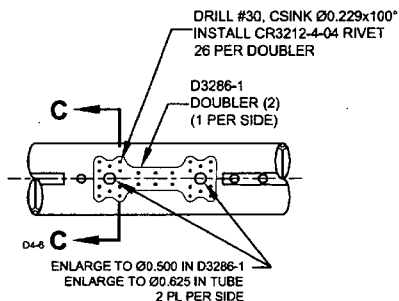


D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

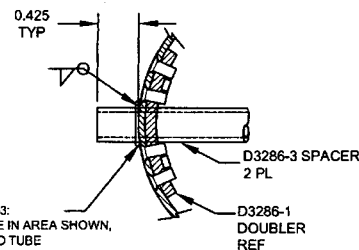


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

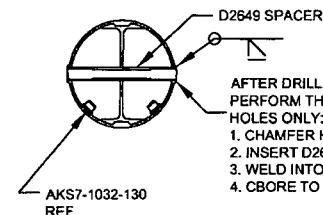


DETAIL B
SCALE 2X
C3-2
C3-3

SECTION C-C C7-6
SCALE NONE

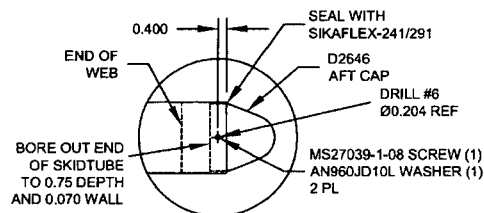


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



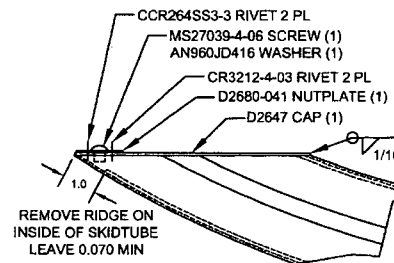
DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5

ORIENTATION OF
D2680-041



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-08-2008

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

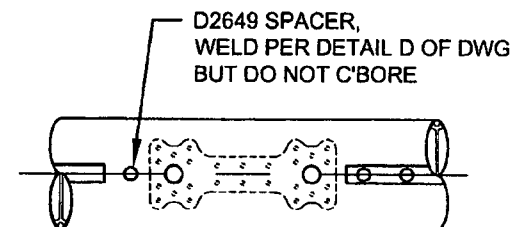
QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

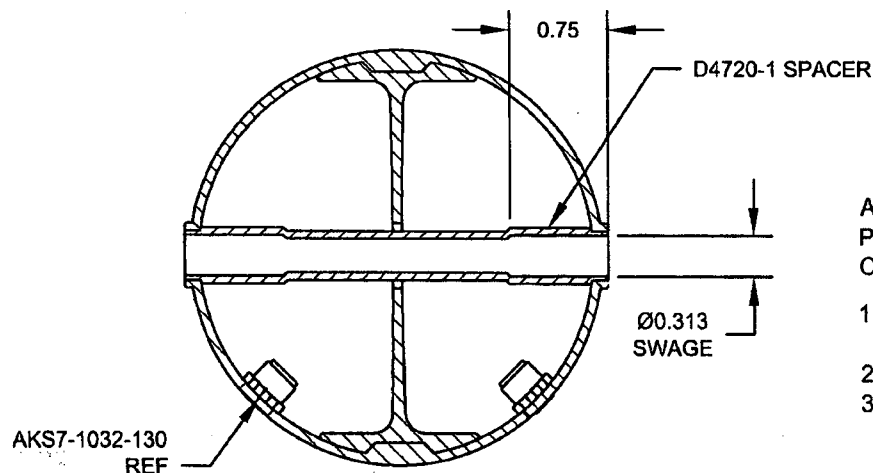
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

